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D3641-1
Job Sheet 191511



21
9-33

Part No: D3641-1

Job Qty: 4 pcs

Part Name: Cover



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/4/19

Job Tracking No:

Due Date: 3/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3641 REV C IPP Rev:A New Issue 07-07-20 JLM Verified By:EC IPP Rev:B ECN 1050 rev.b as per
dwg 08-01-10 DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs		3/15/19	0.00	0.33	Waterjet - Flow		bc 19/03/19
110	QC 2	4 pcs		3/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		bc 19/03/19
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		

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120	QC 8	4 pcs	3/15/19	0.00 0.00	QC 2 - 66	
					QC 2 - 64	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	MAR 19 2019
130	Small Fab - Brake NC - B4B	4 pcs	3/15/19	0.06 0.28	Small Fab - Brake - 1 - B4B	DAS 30 38 9-89
					Small Fab - Brake - 2 - B4B	APR 10 2019
					Small Fab - Brake - 3 - B4B	
140	QC 5	4 pcs	3/15/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	APR 10 2019
					QC 5 - 50	
					QC 5 - 30	
150	Handfinish - 1-1 Chemical-B4B	4 pcs	3/15/19	0.00 0.23	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	D.R. 19/09/11
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	

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				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
180 QC 21 - SA	4 pcs	3/15/19	0.00 0.00	QC 21 - SA - 21	DAS 21 APR 12 2019 9-28
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 110 - (QC2- Inspect parts off machine FAI/FAIB) Descriptions: 120 - (QC8- Inspect parts - second check) 130 - (Form as per dwg) 140 - (QC5- Inspect part completeness to step on W/O) 150 - (Chemical Conversion Coat per QSI005 4.1) 160 - (QC7-Inspect Chemical Conversion Coat) 170 - (Identify as per dwg & Stock Location: _____) 180 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M5052H32S.032	5052-H32 .032 Sheet	3.1948 sf (.7987 ea)	100-Waterjet - Flow - 1	S101050	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M5052H32S.032	3	116	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD		Work Order: 19511
Description: Cover		Part Number: D3641-1
Inspection Dwg: D3641	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.001	0.192	1		V: 0.02	
0.191	+/-0.010	0.193	1		Top	
0.37	+/-0.030	0.37	1			
0.54	+/-0.030	0.54	1			
0.69	+/-0.030	0.69	1			
11.86	+/-0.030	11.86	1			
12.22	+/-0.030	12.22	1			
23.37	+/-0.030	23.37	1			
23.54	+/-0.030	23.54	1			
23.69	+/-0.030	23.69	1			
24.06	+/-0.030	24.06	1			
0.50	+/-0.030	0.50	1			
4.28	+/-0.030	4.28	1			
4.78	+/-0.030	4.78	1			
0.032	+/-0.010	0.032	1			

Measured by: ac	Audited by: DAS	Preliminary Approval:
Date: 19/03/19	Date: 40 9-89	Date:

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	
B	12.03.08	Dwg Rev updated	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S163860



Part: D3641 - 1
Job No: 191511
Serial No/Batch: S163860
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

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Date: 03/19/19